

QWDC- Sup 24/01

Work Order ID 65345



Page 1

January 12, 2011 11:52:22 AM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/26/11 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 11/01/12 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

u
QWDC
Sub 01/21

CK Per CL 11/01/21

110 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

M108436
M115928

3-Grind End Plate flush

PE 11.01.19

2 *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				2	0	8	BF 11-01-19
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		81101119		+2 RM			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2		BL	11-01-19

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⇒ M 11/01/19

2 4

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

11.01.19

2 4

- 1-Assemble Leg Assembly as per Dwg D3272.
- 2-Leave one rivet out until welding is complete.
- 3-Bevel Aft end for welding
- 4-Inspect for foreign object as per QSI 024
- 5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod M108436
- 6-Grind End Plate flush
- 7-Install last rivet as per Dwg.

3.75 cut
3.36 in

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				2	0	RE 11/01/20	
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sub 6/20		12 PM			
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2		11-01-20	

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 Packaging Packaging	Pick Kit Memo	0.00 0.00							
260 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
270 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD350-591-312 Location: <u>Hall</u>	0.00 0.00							

11/12/11 20 8/

42 RM

11/12/11 20 8/

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/01/24 MF

11-01-24

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Page 1

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Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11




Required Date: 1/26/11

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1  Step		Manufactured	No			110	Each	8.0000	1	2		11.01.18	B65344
				<u>Location</u>				<u>Loc Qty</u>					
				WA				8					
				64912				8					
D3067-1  End Plate		Manufactured	No			110	Each	76.0000	1	2		11.01.18	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				76					
				63550				76					
D3219-1  Plate		Manufactured	No			110	Each	73.0000	2	4		11.01.18	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				73					
				63551				73					

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Page 2

Work Order ID: 65345

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 2.00

Required Qty: 2.00

D3066-1 Manufactured No

180 Each

96.0000

2

4



Spacer



11.01.20

Location

Loc Qty

Loc Code

WA

96

63549

46

65072

50

4

MS20600-AD4W4

Purchased No

180 Each

2,031.000

16

32



Rivets



11.01.20

Location

Loc Qty

Loc Code

ST321

2031

113368

38

114181

11

114718

2

115573

147

115640

31

116022

302

116188

1500

32

D3065-041

Manufactured No

180 Each

22.0000

1

2



Step Leg Assembly Hi



11.01.20

Location

Loc Qty

Loc Code

WA

22

63555

22

2

D3067-1

Manufactured No

180 Each

76.0000

1

2



End Plate



11.01.20

Location

Loc Qty

Loc Code

WA

76

63550

76

2

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Shop Packet Print

Page 2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

Work Order ID: 65345

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 2.00

Required Qty: 2.00

AN3-35A

Purchased

No

250

Each

168.0000



Bolt



11/12/11

Location

Loc Qty

Loc Code

ST353

168

116191

100

116419

18

116549

50

D3235-1

Manufactured

No

250

Each

61.0000



Mounting Lug



11/12/11

Location

Loc Qty

Loc Code

ST471

61

61845

1

63547

60

D3278-041

Manufactured

No

250

Each

8.0000



Support Assembly



11/12/11

Location

Loc Qty

Loc Code

ST460

8

64731

8

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

30.0000



Washer



11/12/11

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

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Page 3

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Page 4

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 2.00

Required Qty: 2.00

AN960JD516 NAS1149D0563J Purchased

No

250

Each

34.0000

4

8



Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN5-36A

Purchased

No

250

Each

151.0000

2

4



Bolt

Location

Loc Qty

Loc Code

ST341

151

114292

1

116191

100

116349

50

D2618

Manufactured

No

250

Each

99.0000

2

4



Bushing

Location

Loc Qty

Loc Code

ST019

99

63548

36

65071

63

D2230-3

Manufactured

No

250

Each

94.0000

4



Lug

Location

Loc Qty

Loc Code

ST476

94

55452

2

63312

12

64422

80

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Page 5

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 2.00

Required Qty: 2.00

D2856-400

Manufactured No

250 f

272.5810

1.2

2.4



Abraison Strip



11/12/11

Location

Loc Qty

Loc Code

ST403

272.5810421

56626

0.00004211

59920

56.581

63735

216

2.4

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

3,264.000

2

4



11/12/11

Nut

Location

Loc Qty

Loc Code

ST300

3264

114784

9

115835

755

116391

900

116540

800

116549

800

4

AN4-13A

Purchased No

250 Each

179.0000

8

16



11/16/11

Bolt

Location

Loc Qty

Loc Code

ST357

179

116191

179

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Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

250

Each

1,353.000

2

4



11/12/11 SP

SPL Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1327

115156

5

115594

500

116104

126

116105

496

116548

200

MS21042L4

Purchased

No

250

Each

4,788.000

8

16



11/12/11 SP

SPL Nut

Location

Loc Qty

Loc Code

ST300

4788

1123143

2

115589

10

115621

276

116188

3500

116548

1000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

8.0000

4

8



11/15/11 SP 11/12/11 SP 20

SPL Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

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DART

DESIGN <i>9P</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65345

C211/0112

NO. 11/01/12

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

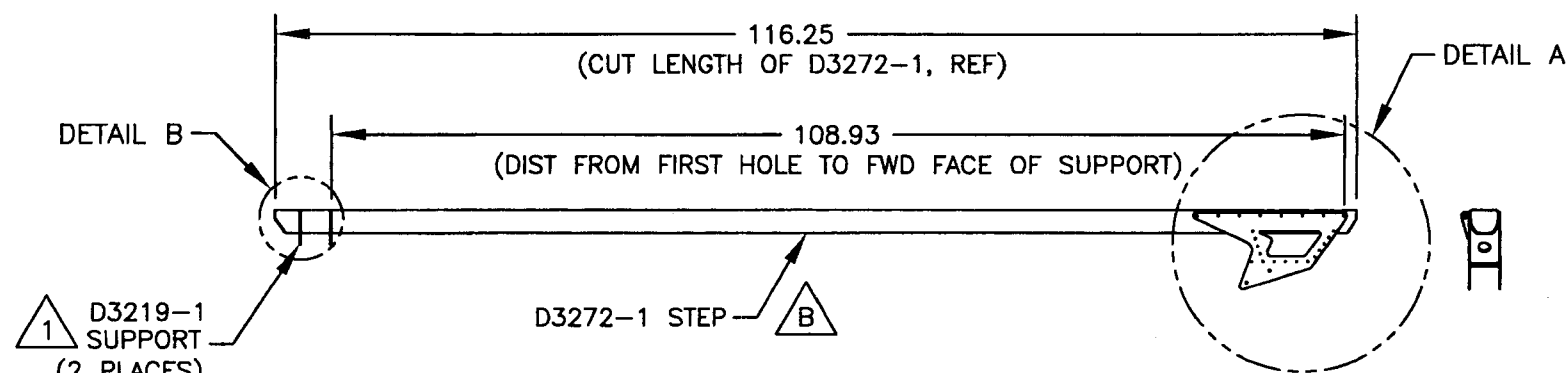
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DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	SHEET 2 OF 3	SCALE
07.05.18	D3272	1:20	
STEP ASSEMBLY, HI LONG			

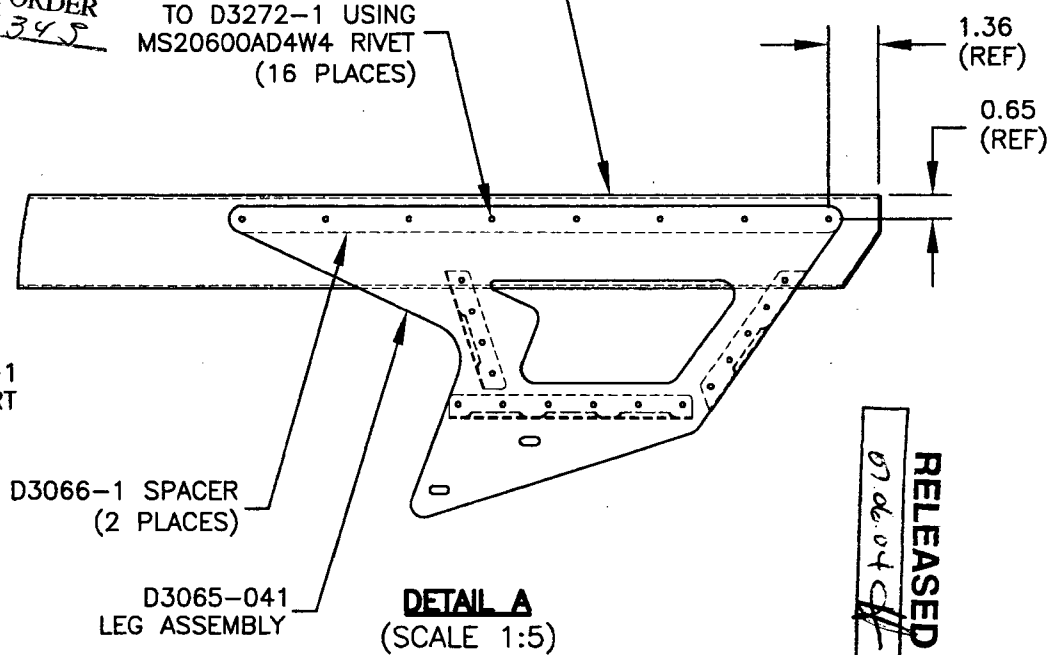
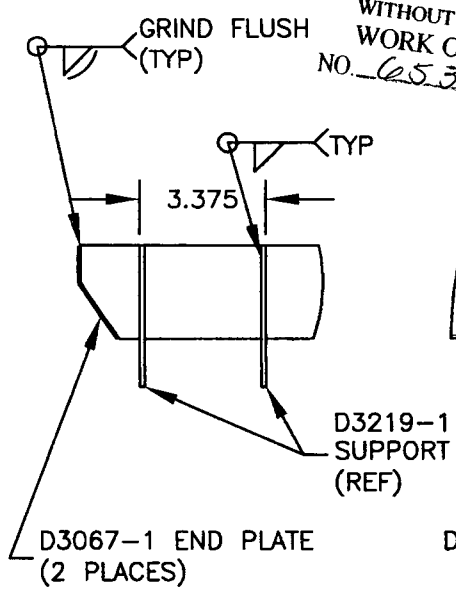


D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

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WORK ORDER
NO. 25345

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS

RIVET D3065-041
TO D3272-1 USING
MS20600AD4W4 RIVET
(16 PLACES)



DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

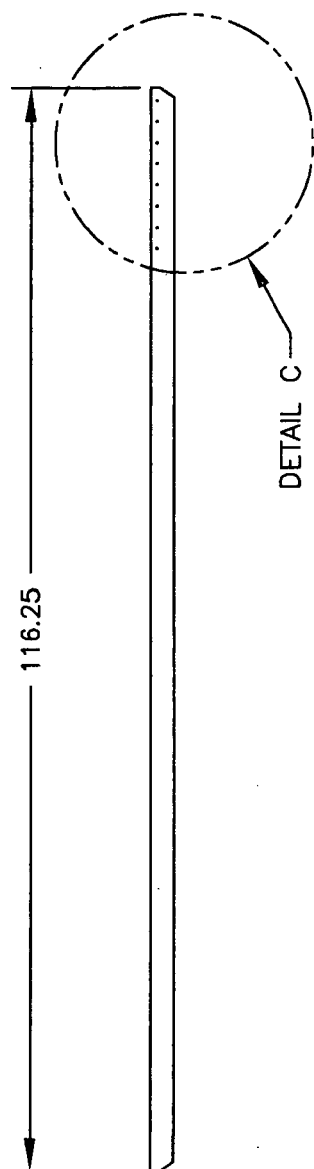
NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>js</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

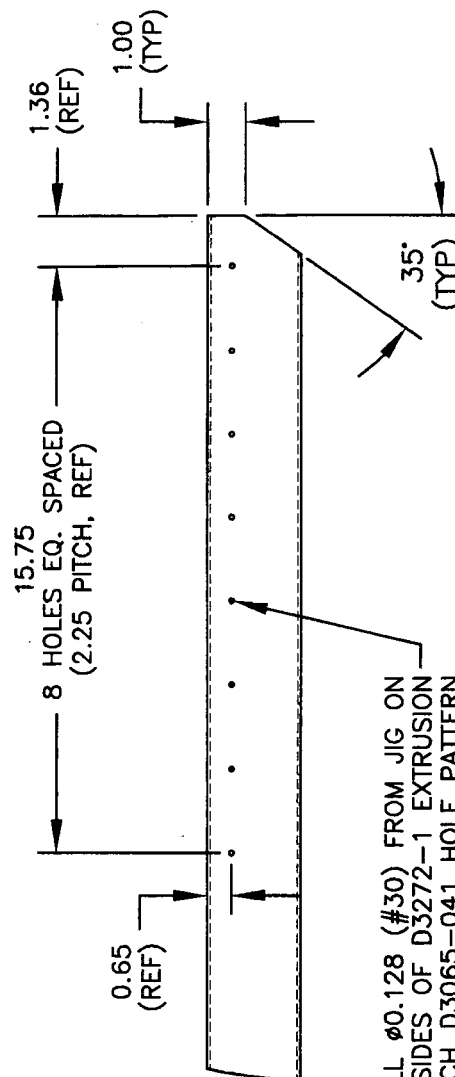
RELEASED

07.06.04 *[Signature]*



DETAIL C

B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

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NO. 65345

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.